Work Order ID 98179

March-08-13 10:25:45 AM

98179 BLUE

Item ID: D206-642-312BL
Revision ID:
Item Name: Skidtube RH

Accept *N900040100*

Setup Start *NS1*
Stop *NS2*

Start Date: 3/08/13 **Start Qty:** 1.00 *1*
Required Date: 3/29/13 **Req'd Qty:** 1.00 *1*
Reference:

Cust Item ID:
Customer:

Approvals: **Process Plan:** ML5 **Date:** 13-03-08 **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
IIN-D206-642	N								
100		0.00							
100	DOCUMENT CONTROL					1			
DC	**Memo**	0.00							
Document Control	Photocopy bluefile and create labels per PPP D206-642-312 CHG00[illegible]								
110	Pick Kit	0.00							
110						1	13-5-22		
Packaging	**Memo**	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120						1			
QC	**Memo**	0.00							
Quality Control									

B101284

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐
- ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

Work Order ID 98179

March-08-13 10:25:45 AM

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Item ID: D206-642-312BL
Revision ID:
Item Name: Skidtube RH

Accept *N900040100*

Setup Start *NS1*
Stop *NS2*

Start Date: 3/08/13 **Start Qty:** 1.00 *1*
Required Date: 3/29/13 **Req'd Qty:** 1.00 *1*
Reference:

Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00	DAS 06-05-23		13/5/23	2			
130	Packaging								
Packaging	**Memo**	0.00							
Packaging	Identify and pack for shipping as per PPP D206-642-312 Location: _____ PPP Rev: SH 2								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	**Memo**	0.00							
Quality Control						MLJ 13-05-23			

MLJ 13-05-23

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐
- ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

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- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

Picklist Print

March-08-13 10:25:49 AM

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Work Order ID: 98179

98179

Parent Item: D206-642-312BL

*D206-642-312BL *

Parent Item Name: Skidtube RH

Start Date: 3/08/13 **Required Date:** 3/29/13

Start Qty: 1.00 **Required Qty:** 1.00

Comments: IPP Rev: J 05.10.11Added D3429-1 per CHG004KJ/CP/JLM/EC
IPP Rev:K 07-12-04 ECN 1080p DD verified by:ec
IPP Rev:L 08-09-29 as per DSI9421 DD verified by: EC IPP
Rev:M 09-03-02 as per DSI9440 rev.a verified by:EC
IPP Rev:N 09-03-03 as per DSI9421 rev.b verified by:EC IPP Rev:O
as per REV.N DD 10.04.19 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D206-642-341 *D206-642-341 * Replacement Skidtube		Manufactured	No			110	Each	3.0000	0 **	1	10/284		

Location	Loc Qty	Loc Code
FG	1	
93119	1	
FG082	2	
36550	1	
69952	1	

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D206-648-013 *D206-648-013* GHW Modification		Manufactured	No			110	Each	19.0000	0 **	1	98438		

Location	Loc Qty	Loc Code
FG125	18	
93355	13	
93930	5	
PKG002	1	
95417	1	

ATTN: D3414-041 BLUE

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐
- ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

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- ☐ Cuffs
- ☐ Heat Treat
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- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
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- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
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- ☐ Drill Holes
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- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
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- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other _____

Picklist Print

March-08-13 10:25:49 AM

Work Order ID: 98179

98179

Parent Item: D206-642-312BL

*D206-642-312BL *

Parent Item Name: Skidtube RH

Start Date: 3/08/13 **Required Date:** 3/29/13

Start Qty: 1.00 **Required Qty:** 1.00

D2932-2	Manufactured	No	110	Each	18.0000	0 1

D2932-2

Saddle RH Out, 206

Location	Loc Qty	Loc Code
ST422	12	
89926	2	
96695	9	96695
96706	1	
ST427	6	
93155	6	

BLUE

D2933-2	Manufactured	No	110	Each	22.0000	0 1

D2933-2

Saddle RH In, 206

Location	Loc Qty	Loc Code
ST	1	
96708	1	
ST422	15	
90278	3	
96700	12	96700
ST427	6	
93165	6	

BLUE

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐
- ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

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- ☐ Temperature/Cure
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- ☐ Wrong Stock Pulled
- ☐ Other _____

Picklist Print

March-08-13 10:25:49 AM

Work Order ID: 98179

98179

Parent Item: D206-642-312BL

*D206-642-312BL *

Parent Item Name: Skidtube RH

Start Date: 3/08/13 **Required Date:** 3/29/13

Start Qty: 1.00 **Required Qty:** 1.00

D2938-2	Manufactured	No	110	Each	12.0000	1

D2938-2

Saddle RH Out, 206

Location	Loc Qty	Loc Code
ST422	2	96702
75102	1	
96709	1	
ST428	10	
91962	4	
93422	6	

BLUE

D2939-2	Manufactured	No	110	Each	28.0000	1

D2939-2

Saddle RH In, 206

Location	Loc Qty	Loc Code
ST422	15	
78955	1	
79238	1	
96704	12	
96710	1	96710
ST428	13	
91309	1	
93180	6	
93889	6	

BLUE

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

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General

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- ☐ Other

Picklist Print

March-08-13 10:25:49 AM

Work Order ID: 98179

98179

Parent Item: D206-642-312BL

*D206-642-312BL *

Parent Item Name: Skidtube RH

Start Date: 3/08/13 **Required Date:** 3/29/13

Start Qty: 1.00 **Required Qty:** 1.00

AN3-41A	Purchased	No	110	Each	2,137.000	8

AN3-41A

Bolt

SM

Location	Loc Qty	Loc Code
FG	20	
122416	20	
ST353	39	
123355	39	123355 MD
ST513	2078	
123355	2078	

D2652	Manufactured	No	110	Each	866.0000	16

D2652

Bushing

SM

Location	Loc Qty	Loc Code
FG	44	
31985	44	
ST014	822	
83251	7	
88503	10	
93373	16	
93374	64	
93685	304	93685 MD
93934	1	
95147	203	
96451	205	
96505	12	

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

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DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

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- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

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Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

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Landing Gear

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Picklist Print

March-08-13 10:25:49 AM

Work Order ID: 98179

Parent Item: D206-642-312BL

Parent Item Name: Skidtube RH

98179
*D206-642-312BL *

Start Date: 3/08/13 **Required Date:** 3/29/13

Start Qty: 1.00 **Required Qty:** 1.00

MS21042L3	Purchased	No		110	Each	6,501.000	8 (8)

MS21042L3
Nut

**

Location	Loc Qty	Loc Code
FP001	3	
122141	3	
GA	238	
122452	238	
ST314	268	
117885	32	
119017	55	
119075	138	
123265	43	
ST506	5992	
123900	1992	
124291	4000	124291

AN960JD10	NAS1149D0363J	Purchased	No	110	Each	0.0000	8 (8)

AN960JD10
Washer

**

124392

AN5-10A		Purchased	No	110	Each	895.0000	4 (4)

AN5-10A
Bolt

**

Location	Loc Qty	Loc Code
GA	50	
122800	50	
ST350A	845	
123522	345	
124805	500	124805

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
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Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

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☐ Cuffs
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Ripples in Bend
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☐ Positioned Wrong
☐ Power Loss/Surge

☐ Pressure/Forced
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other

Picklist Print

March-08-13 10:25:49 AM

Work Order ID: 98179

Parent Item: D206-642-312BL

Parent Item Name: Skidtube RH

98179
*D206-642-312BL *

Start Date: 3/08/13 **Required Date:** 3/29/13

Start Qty: 1.00 **Required Qty:** 1.00

AN5-11A — Purchased — No — 110 — Each — 240.0000

AN5-11A
Bolt

Location	Loc Qty	Loc Code
ST362	240	
123533	240	

AN960JD516 NAS1149D0563J Purchased — No — 110 — Each — 2.0000

AN960JD516
Washer

Location	Loc Qty	Loc Code
ST504	2	
1069059	2	

AN4-6A — Purchased — No — 110 — Each — 3,073.000

AN4-6A
Bolt

Location	Loc Qty	Loc Code
ST355	117	
123355	117	
ST514	2956	
123355	2956	

AN960JD416 NAS1149D0463J Purchased — No — 110 — Each — 0.0000

AN960JD416
Washer

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐
- ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other _____

Picklist Print

March-08-13 10:25:49 AM

Work Order ID: 98179

98179

Parent Item: D206-642-312BL

*D206-642-312BL *

Parent Item Name: Skidtube RH

Start Date: 3/08/13 **Required Date:** 3/29/13

Start Qty: 1.00 **Required Qty:** 1.00

MS21042L4	Purchased	No	110	Each	4.273.000	12

MS21042L4

Nut

**

12

SHP

Location		Loc Qty	Loc Code
FP001		318	
	122452	306	
	8182	12	
FP-001		12	
	8182	12	
GA		40	
	121444	40	
ST314		75	
	116548	12	
	119017	20	
	123248	27	
	123355	16	
ST506		828	
	123900	828	
ST518		3000	
	124231	3000	

125535 MD

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

Picklist Print

March-08-13 10:25:49 AM

Work Order ID: 98179

98179

Parent Item: D206-642-312BL

*D206-642-312BL *

Parent Item Name: Skidtube RH

Start Date: 3/08/13 **Required Date:** 3/29/13

Start Qty: 1.00 **Required Qty:** 1.00

D3407-043	Manufactured	No	110	Each	36.8300	[redacted] 1

D3407-043

Tow Ring

**

Location	Loc Qty	Loc Code
ST421	1	
89712	1	
ST463	35.83	
68339	2	
78841	1	
83326	0.83	
85478	10	
86563	1	
87657	3	
93938	10	
95924	8	

98157

BLUE

D3456-1	Manufactured	No	110	Each	154.0000	[redacted] 1

D3456-1

Washer

**

Location	Loc Qty	Loc Code
FG	7	
25701	7	
ST044	50	
97542	50	
ST047	97	
80252	1	
89237	25	
93780	50	
96570	21	

97542

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐
- ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
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- ☐ Mislabeled
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- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

Picklist Print

March-08-13 10:25:49 AM

Work Order ID: 98179

Parent Item: D206-642-312BL

Parent Item Name: Skidtube RH

98179
*D206-642-312BL *

Start Date: 3/08/13 **Required Date:** 3/29/13

Start Qty: 1.00 **Required Qty:** 1.00

D3457-1	Manufactured	No	110	Each	106.0000	2

D3457-1
Washer

Location	Loc Qty	Loc Code
FG	10	
32409	10	
ST047	96	
89993	24	
93216	8	
95755	40	
97683	24	

95755 ML

MS21043-4	Purchased	No	110	Each	1,204.000	1

MS21043-4
Nut

Location	Loc Qty	Loc Code
FG	36	
104603	36	
GA	97	
121652	97	
ST315	1071	
121162	25	
123021	500	
123525	29	
123900	517	

125654 ML

AN4C5A	Purchased	No	110	Each	251.0000	1

AN4C5A
BOLT

Location	Loc Qty	Loc Code
ST355	251	
122599	100	
123265	151	

123265 ML

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐
- ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
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- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

Picklist Print

March-08-13 10:25:49 AM

Work Order ID: 98179

98179

Parent Item: D206-642-312BL

*D206-642-312BL *

Parent Item Name: Skidtube RH

Start Date: 3/08/13 **Required Date:** 3/29/13

Start Qty: 1.00 **Required Qty:** 1.00

AN960C416	NAS1149C0463R	Purchased	No	110	Each	0.0000	1

AN960C416

washer

SM

** 123248 ML

D3413-1		Manufactured	No	110	Each	84.0000	1

D3413-1

Ring

SM

Location	Loc Qty	Loc Code
ST421	8	
80224	3	
88025	5	
ST464	76	
91117	76	

96882 ML

BLUE

D2712		Manufactured	No	110	Each	1,052.000	10

D2712

Set Screw

SM

Location	Loc Qty	Loc Code
FG	50	
29962	50	
ST016	1002	
91229	12	
93686	990	

93686 ML

D2934		Manufactured	No	110	Each	77.0000	2

D2934

Saddle Spacer

SM

Location	Loc Qty	Loc Code
FG	6	
31929	6	
ST022	71	
89975	40	
93892	31	

89975 ML

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐
- ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
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- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

Picklist Print

March-08-13 10:25:49 AM

Work Order ID: 98179

98179

Parent Item: D206-642-312BL

*D206-642-312BL *

Parent Item Name: Skidtube RH

Start Date: 3/08/13 **Required Date:** 3/29/13

Start Qty: 1.00 **Required Qty:** 1.00

D2935	Manufactured	No		110	Each	68.0000

D2935

Saddle Spacer

Location	Loc Qty	Loc Code
FG	6	
31793	6	
ST022	62	
88536	4	
90172	14	
93393	44	

98474

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐
- ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
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- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

Work Order ID 98179

March-08-13 10:25:45 AM

98179 BLUE

Item ID: D206-642-312BL
Revision ID:
Item Name: Skidtube RH

Start Date: 3/08/13 **Start Qty:** 1.00 *1*
Required Date: 3/29/13 **Req'd Qty:** 1.00 *1*
Reference:

Accept *N900040100*

Setup Start *NS1*
Stop *NS2*

Cust Item ID:
Customer:

Approvals: **Process Plan:** MLS **Date:** 13-03-08 **Tooling:** **Date:**
QC: **Date:** **SPC (Y/N):** **Date:**

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
IIN-D206-642	N								
100									
100	DOCUMENT CONTROL	0.00							MLS 13-05-22
DC									
Document Control	**Memo**	0.00							
	Photocopy bluefile and create labels per PPP D206-642-312 CHG006 007 see attachment								
110	Pick Kit	0.00							ML
110									
Packaging									
Packaging	**Memo**	0.00							
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC									
Quality Control	**Memo**	0.00							

Change Record

Part Number: D206-642-312 / -312BL / -312G

Description: SKIDTUBE , RH

CHG #	DATE	BY	RELEVANT DOCUMENTS	ECN #
001	98.12.14	DS	MDL-D119-646 REV I	
002	99.04.28	DS	MDL-D206-642 REV J	
			ADDED SADDLE SPACERS PER DSI 9150 REV A	
			D2655 TOW RING SHIPPED LOOSE RATHER THAN INSTALLED	
			ON SKIDTUBE	
003	00.03.14	DS	CHANGE TO D2968-041 TOW RING PER DSI 9181 REV A	
004	05.10.04	CP	ADD D3429-1 WEARPAD PER MDL-D206-642 REV O	
005	08.10.07	KJ	DSI 9421 REV A, D2650 REV F	08-538
006	09.02.19	KJ	DSI 9421 REV B, DSI 9440 REV A, D206-648 REV B, D3414 REV B	09-531
007	12.11.16	KJ	DEO-D2650-F-1, DEO-D3804-A-1, D4720 REV A	12-679